

Date: Wednesday, 2/28/2007 8:23:53 AM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COWL BRACKET
Job Number	: 30984		
Estimate Number	: 12755	Part Number	: D2127251120
P.O. Number	: N/A	Drawing Number	: D212-725-1 REV B
This Issue	: 2/28/2007 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: B
First Issue	: N/A	Material	: N/A
Previous Run	: N/A	Due Date	: 3/7/2007
Written By	: <i>JLM 07-02-28</i>	Qty:	4 Um: Each
Checked & Approved By	: <i>JLM</i>		
Comment	: Est Rev:A New Issue 07-02-28 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
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Comment: Qty.: 0.2835 f(s)/Unit Total : 1.1340 f(s)

6061-T6 Bar 1.0" x 2.0"

Batch: *M19054*

JLM 07-02-28

4.

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank 3.250 " long

JLM 07-02-28

4.

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA674 Rev: *B* & Dwg D121-725-1 Rev: *B*.

2-Deburr per dwg D212-725-1

JLM 07-02-28

4.

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JLM 07-02-28

4.

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JLM 07-02-28

4.

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Drawing Name: COWL BRACKET

Job Number: 30984

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

✓

Handwritten initials

07-02-28 (4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten signature and date 7/4/28 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Handwritten signature and date 7/4/28 (4)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



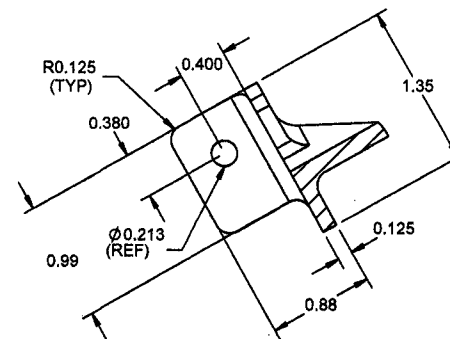
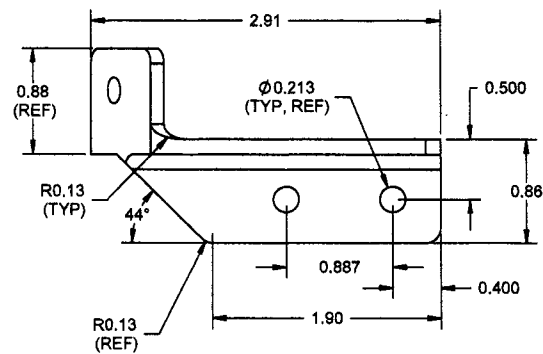
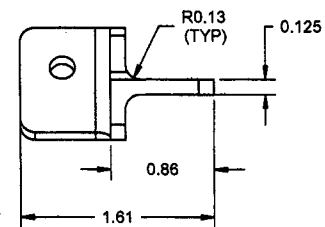
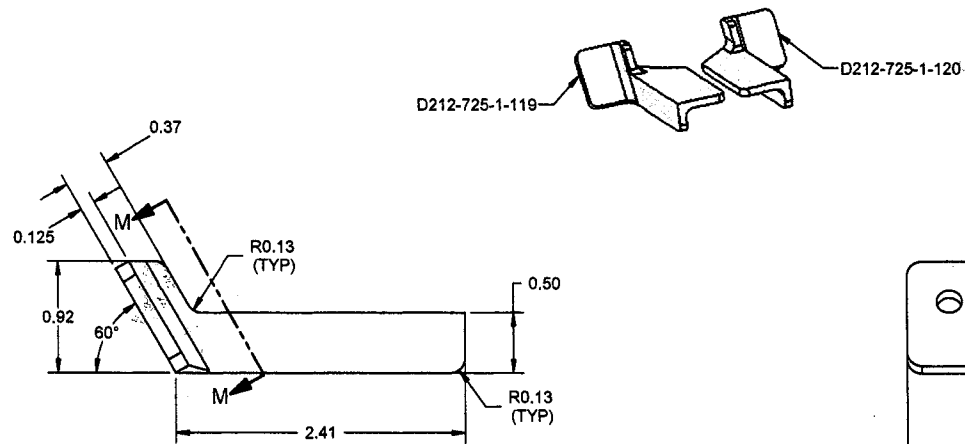
Comment: FINAL INSPECTION/W/O RELEASE

Handwritten signature, date 07/02/28, and circled number 4

Job Completion



07-02-28



**D212-725-1-119 COWL BRACKET, SHOWN
D212-725-1-120 OPPOSITE
($\phi 0.213$ HOLES TRANSFER FROM AIRCRAFT)**

SECTION M-M

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-225/8) BAR (REF. DART SPEC. M6061T6)
- 2) FINISH: ACID ETCH ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. B SHEET 38 OF 38
DATE 07.01.29		TITLE 212S DETAIL PARTS	SCALE 1:1
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DART AEROSPACE LTD		Work Order:	
Description: <i>Paul Bucket</i>		Part Number:	<i>D212-725-1-120</i>
Inspection Dwg: <i>D212-725</i> Rev: <i>B</i>		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<i>.37</i>	<i>+/- .030</i>	<i>.376</i>	<i>-</i>			
<i>.125</i>	<i>+/- .010</i>	<i>.125</i>	<i>-</i>			
<i>.92</i>	<i>+/- .030</i>	<i>.922</i>	<i>-</i>			
<i>.50</i>	<i>+/- .030</i>	<i>.501</i>	<i>-</i>			
<i>R.13</i>	<i>+/- .030</i>	<i>R.125</i>	<i>-</i>			
<i>2.91</i>	<i>+/- .030</i>	<i>2.903</i>	<i>-</i>			
<i>.38</i>	<i>+/- .030</i>	<i>.878</i>	<i>-</i>			
<i>.86</i>	<i>+/- .030</i>	<i>.856</i>	<i>-</i>			
<i>1.61</i>	<i>+/- .030</i>	<i>1.615</i>	<i>-</i>			
<i>.125</i>	<i>+/- .010</i>	<i>.127</i>	<i>-</i>			
<i>.860</i>	<i>+/- .030</i>	<i>.854</i>	<i>-</i>			
<i>1.35</i>	<i>+/- .030</i>	<i>N/A</i>				
<i>.88</i>	<i>+/- .030</i>	<i>.874</i>	<i>-</i>			
<i>.99</i>	<i>+/- .030</i>	<i>.993</i>	<i>-</i>			

Measured by: <i>JA</i>	Audited by: <i>B</i>	Prototype Approval:
Date: <i>07.02.28</i>	Date: <i>07.02.28</i>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	